Dart Aerospace Ltd.

User:

Wednesday, 18/06/2008 1:26:36 PM

Julie Lecoca

Process Sheet

Customer

Written By

: CU-DAR001 Dart Helicopters Services

Job Number

: 39919 : 10324

: 18/06/2008

Estimate Number

P.O. Number

This Issue Prsht Rev.

: NC

First Issue **Previous Run**

: // : 38274

Type

S.O. No. :

: MACHINED PARTS

Checked & Approved By Comment

: Est RevC 02.04.10 Re-format NG

Drawing Name

: SADDLE BLOCK

Part Number : D1049

: D1049 REV A **Drawing Number**

: N/A **Project Number**

Drawing Revision

Material

: 11/07/2008 **Due Date**

Qty:

Each

Additional Product

Job Number: -----

Seq. #:





1.0



Description:

6061-T6 Bar .750 x .250



Comment: Qty.: 0.1749 f(s)/Unit Total: 8.7465 f(s) Material; 6061-T6 bar .750 wide x .250 thick. Batch

Batch

2.0

£.

SHEAR

SHEAR



Comment: SHEAR.

Cut Blanks: 2.000" long

HAAS1



HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio FA217 & Dwg D1049

2-Deburr

QC2 4.0

INSPECT PARTS AS THEY COME OFF MACHINE

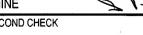




Comment: INSPECT ARTS AS THEY COME OFF MACHINE

5.0

SECOND CHECK



Comment: SECOND CHECK



POSITIVE RECALL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
	-										
						4.0					

Part No:	PAR #:	_ Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C (Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		Verification	A	Annroval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
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NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 1:26:36 PM IJser: Julie Lecocq **Process Sheet** Drawing Name: SADDLE BLOCK Customer: CU-DAR001 Dart Helicopters Services Job Number: 39919 Part Number: D1049 Job Number: Seq. #: **Machine Or Operation: Description:** HAND FINISHING1 HAND FINISHING RESOURCE #1 6.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 7.0 POWDER COATING POWDER COATING m102316 Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 START TIME: **OVEN TEMPERATURE:** FINISH TIME: 8.0 QC3 POWDER COAT/CHEMICAL CONVERSION 9.0 PACKAGING 1 PACKAGING RESOUR Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CH	IANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					!		7

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
4.4			QA: N/C C	losed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)						
	Description of NC		Corrective Action Section B		Varification	Approval	Anneoval
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
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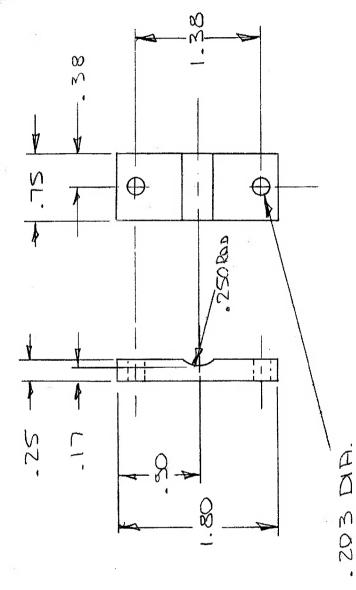
NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39919
Description: Saddle	Part Number:	D1049
Inspection Dwg: D1049 Rev:		Page 1 of 1

Inspection Dwg	: D1049	Rev:				Pa	ge 1 of 1
	FI	IRST ARTICLE			ECKLIST otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		nments
Ø0.203	+0.005 -0.000	6.203					
1.380	+/-0.010	1.380	/				
0.75	+/-0.030	.750	/				
0.25	+/-0.030	-250					
0.90	+/-0.030	901					-
0.17	+/-0.030	120					
R0.250	+/-0.010	R.250					
0.38	+/-0.030	-375					
1.80	+/-0.030	1.797					
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Rev Date	Change			8		Revised by	Approved

	Date:	T CHOIXC	Date. 05/01/09	Date.	IN/A
Rev	Date	Change		Revised,by	Approved
Α	03.10.07	New Issue		KJ/RF	- 4
				7,77	* 1

RELEASED 197/09/02 BJ



MATTERIAL: SOSZ-H32

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FINISH: PONDER CORT



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